

Work Order ID 121779

Wednesday, July 02, 2014 3:34:18 PM

121779

Page 1

Item ID: D2586 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Latch
Start Date: 7/02/14 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 7/02/14 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 14-07-03 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2586	Rev E								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>24883</u>								
	Possible Supplier: Southco, P/N: C2-32-25 TCH Sales								
	Certification Required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	1-Attach certification								
	2-Keep Key with latch								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

14/07/04 50

14/7/7 (50)

(50)

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					50x			14/08/29
Small Fab	Memo	0.00							
Small Fab	1-Drill Hole to 0.191"								
	2-Counterface as per Dwg D2586								
	3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						50			14/08/28
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>SI483</u>	0.00							
150						50x			AUG 29 2014
Packaging	Memo	0.00							
Packaging	***Ensure key is bag with latch***								

DAS
36
9-89

DAS
38
9-89

DAS
28
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 14-09-02
MLJ 14-08-29

DQA: _____ Date: _____



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121779

D2586

Required Date: 7/02/14

Required Qty: 50.00

Comments: IPP E02.01.31Added Inspect level 21NG IPP RevF: add not to
keep key with latch DD 10.02.10 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
C23225		Purchased	No			110	Each	45.0000	1	50			
C23225 DOOR LATCH													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		45							
					119746	45							
D3015-7		Manufactured	No			130	Each	181.0000	1	50			
D3015-7 Lock Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST015		181							
					108429	85							
					113684	1							
					120288	95							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

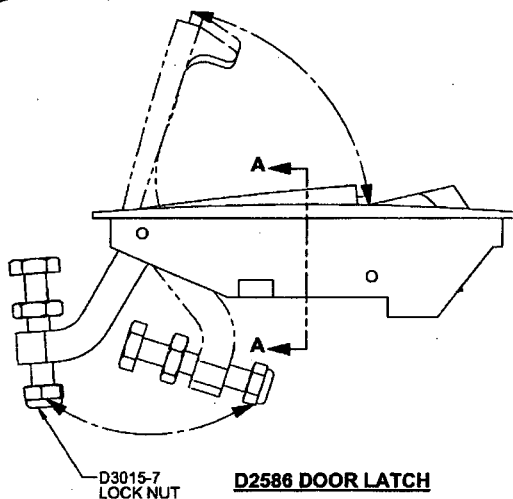
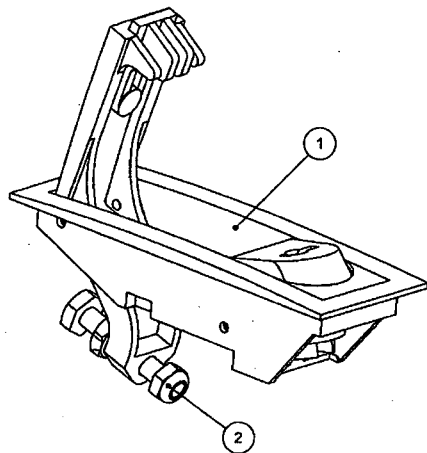
Work Order update only ☐

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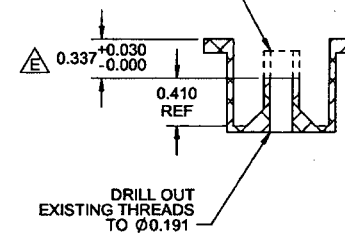
D2586 DOOR LATCH

ITEM	QTY D2586	P/N	DESCRIPTION
	X	D2586	LATCH ASSEMBLY
1	1	C2-32-25	LATCH
2	1	D3015-7	LOCK NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 121779 MJS
14-07-03

CBORE TOP TO
REMOVE MATERIAL FROM
EXISTING BOSS



SECTION A-A

RELEASED
2011-07-04

NOTES:

- 1) MATERIAL: PURCHASE FROM SOUTHCO
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs APPROX

E	REFORMAT. ZONE B3 UPDATED DIMENSIONS FOR CBORE. (SEE CAR 11-32)	AJS	11.06.13
D	ADD 3015-7 P/N; UPDATE DRAWING	CB	06.10.19
C	REVISED CBORE DEPTH	KE	97.09.03
B	CHANGED CBORE DEPTH	KE	97.07.23
A	NEW ISSUE	KE	98.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2586	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH	NTS
DATE	11.06.13	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24883**

Purchase Order Date 7/4/2014

PO Print Date 7/4/2014

Page Number 1 of 1

Order From :

VC-TCH001

Ship To : DART AEROSPACE LTD

TCH SALES INC.
C/O TH1212
PO BOX 4290 STN A
TORONTO, ON M5W 0E1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 416 299 0089

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	C23225 AS PER DWG D2586 REV. E B121779	DOOR LATCH	7/11/2014 Yes 7/11/2014		50.00 Each	\$16.00	\$800.00
Line Total:							\$800.00
2	71401-45 PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A025 CERTIFICATE OF CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT	PROCUREMENT QUALITY CLAUSES	7/11/2014 No 7/11/2014		1.00	\$0.00	\$0.00
Line Total:							\$0.00
PO Total:							\$800.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

1

Change Date:

7/4/2014

Conditions de vente:
Tous les retours de marchandises sont soumis à des frais de manutention de 15% et à l'autorisation.
Veuillez signaler toutes les anomalies ou irrégularités dans les sept jours.
Nous avons le droit d'imposer dans frais de recouvrement et de procédure de 25%, ainsi qu'un intérêt de 2
par mois (ou 24% par an) sur tous les comptes en souffrance.
Les biens faisant l'objet de la présente facture demeurent la propriété du vendeur jusqu'à parfait paiement